OPTIMIZED SHIFTING STRATEGIES AS A
FUNCTION OF STRIP WIDTH

∧ This application is a 35 USC 371 of PCT/EP04/12796, filed 11/11/2004.

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The invention concerns a method for optimizing shifting

strategies as a function of strip width for the best possible

utilization of the advantages of CVC/CVC^{plus} technology in the

operation of strip edge-oriented shifting in four-high and six-

high rolling stands, comprising a pair of work rolls and a pair

of backup rolls and, in addition, in the case of six-high

rolling stands, a pair of intermediate rolls, wherein at least

the work rolls and the intermediate rolls interact with axial

shifting devices, and wherein each work roll and intermediate

roll has a barrel lengthened by the amount of the CVC shifting

stroke with a one-sided setback in the area of the barrel edge.

In the past, quality requirements for cold-rolled strip

with respect to thickness tolerances, attainable final

thicknesses, strip crown, strip flatness, surfaces, etc., have

steadily increased. In addition, the great variety of products

on the market for cold-rolled plates is leading to an

increasingly varied product spectrum with respect to the